

Work Order ID 73308

Wednesday, August 31, 2011 10:47:37 AM



Page 1

Item ID: D2876

Accept



Setup Start



Revision ID:

Item Name: Saddle Spacer

Stop



Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: UMF

Date: 11-09-01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2876	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

I-Cut as per Dwg D 2876 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

6061. 100

B11-11-2

36

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-11-2

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11-11-03

(36)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

Page 2

Accept

[illegible]

Setup Start

Stop

[illegible][illegible]**Cust Item ID:**

Start Date: 9/1/2011 **Start Qty:** 30.00

Required Date: 9/15/2011 **Req'd Qty:** 30.00

Customer:

Reference:

Run Start



Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

[illegible]

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

Small Fab

0.00

Small Fab

Memo

Small Fab

Remove tabs and Tumble

140

0.00

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

Hand Finishing

150

0.00

QC3- Inspect Part Finish

0.00

QC

Memo

Quality Control

n/A.

36 Br 11-11-3

36x8 m/l 11/11/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 73308

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Wednesday, August 31, 2011 10:47:38 AM

Item ID: D2876

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 9/1/2011 Start Qty: 30.00



Cust Item ID:

Required Date: 9/15/2011 Req'd Qty: 30.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location

SF 25

0.00



Packaging

Memo

0.00

Packaging

SP 11-11-03

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/11/3

ME 11-11-03

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 10:47:35 AM

Page 1

Work Order ID: 73308



Parent Item: D2876



Parent Item Name: Saddle Spacer



Start Date: 9/1/2011

Required Date: 9/15/2011

Start Qty: 30.00

Required Qty: 30.00

Comments: Esr Rev:B 00.05.19 Added inspect level 8 EC
IPP Rev:C Now M6061-T6 06-06-23 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.100 		Purchased	No			100	sf	108.4000	0.0516	1.629474	2		
											B 11-11-2		

6061-T6 .100 Sheet

LocationLoc QtyLoc Code

MAT021

108.4

102201

1

118072

22.9

118523

84.5

118523

(36)

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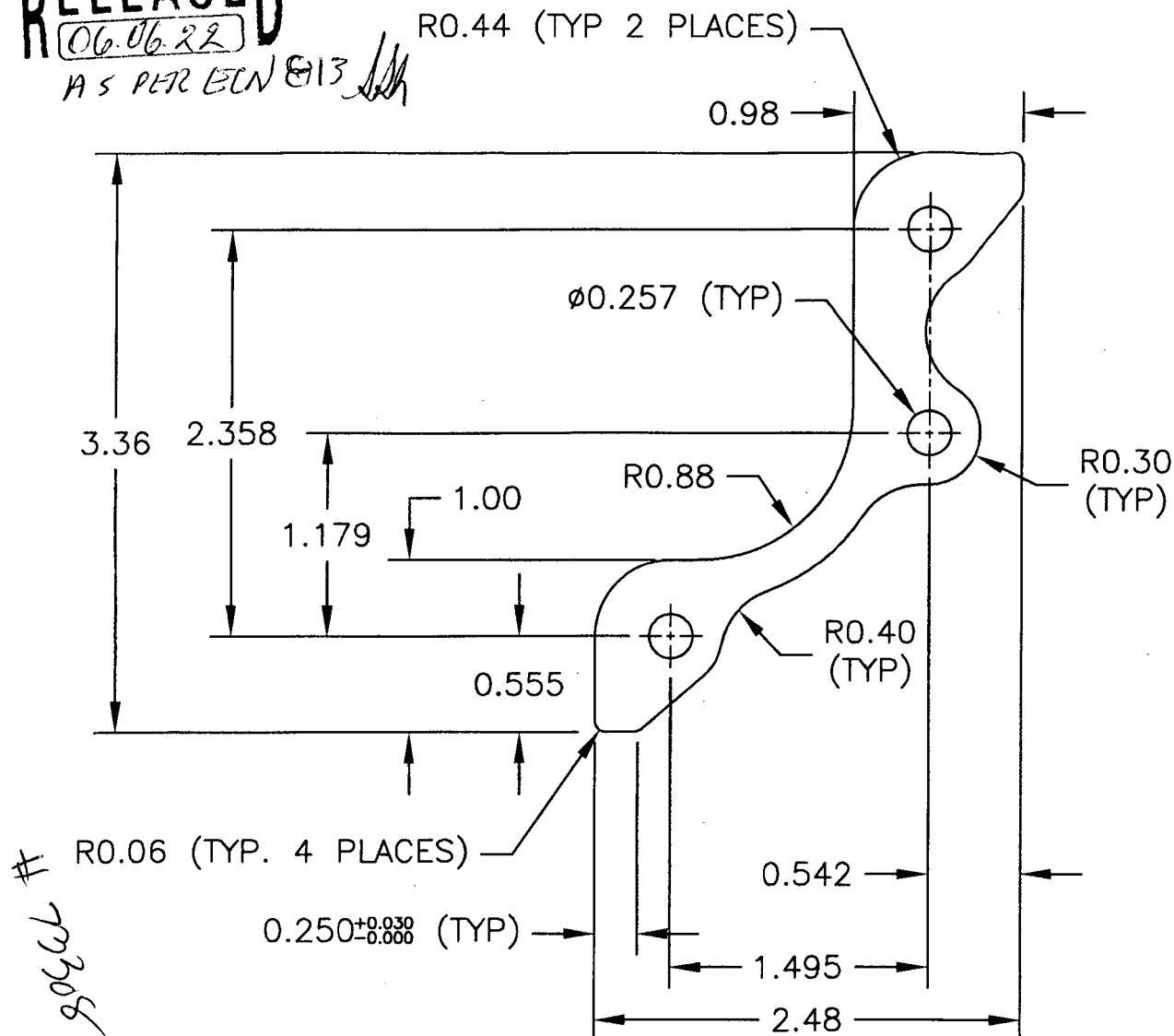
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2876	REV. B SHEET 1 OF 1
DATE 06.06.02		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.06.02	MATERIAL CHANGE	

RELEASED
06.06.22

AS PER ECN 813 *[Signature]*



NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.100" THICK
(REF DART SPEC M6061T6S.100)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.100" THICK
(REF DART SPEC M5052H32S.100)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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